

Date: Friday, 12/7/2007 10:20:34 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 36179	
Estimate Number : 12464	
P.O. Number : <u>N/A</u>	Part Number : D35087
This Issue : 12/7/2007 S.O. No. : <u>NA</u>	Drawing Number : D3508 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NA</u> Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 31198	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 12/14/2007 Qty: 6 Um: Each
Checked & Approved By : <u>[Signature]</u> 07.12.07	
Comment : Est Rev:A New Issue 06-06-20 JLM	
Est Rev:B Now SS as per Rev B 06-12-15 JLM	
Est Rev:C Rev C dwg 07-12-06 DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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2.6176



Comment: Qty.: 0.3272 sf(s)/Unit Total : 1.9631 sf(s)
304 SS .038" THK
(M304S20GA)
Batch: 106027 HB 07-12-10

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3508
Dwg Rev: C
Prog Rev: C

HB 07-12-10

⑧

2-Deburr if necessary HB 07-12-10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 07-12-10



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 07/12/10 XS counter

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
1-Form on brake using DT8326 and DT8261 as per Dwg D3508

5 07/12/11 ⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/12/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/7/2007 10:20:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 36179

Part Number: D35087

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

07/12/11 (X8)

7.0

POWDER COATING

POWDER COATING



M105642



(8X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-h 07/12/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



els

Comment: INSPECT POWDER COAT

07-12-13

(X8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-15

W

07-12-13

(X8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

07/12/13

Job Completion



min 2007/12/13

W

Dart Aerospace Ltd

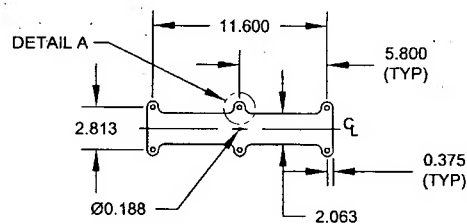
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

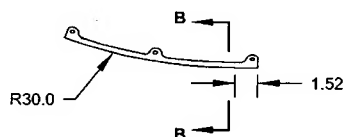
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

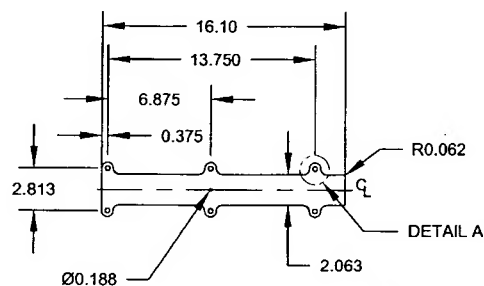
NOTE: Date & initial all entries



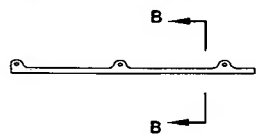
D3508-1 FLAT PATTERN



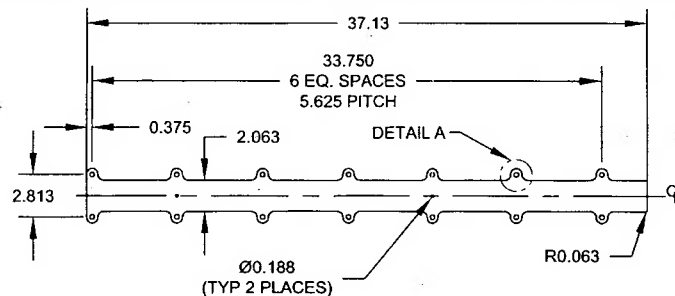
**D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)**



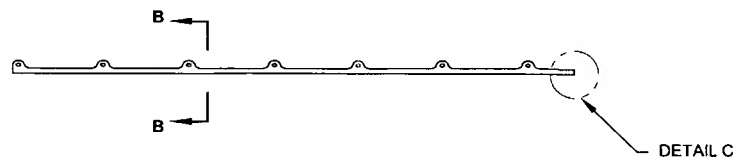
D3508-7F FLAT PATTERN



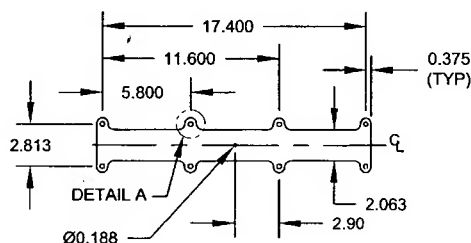
**D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)**



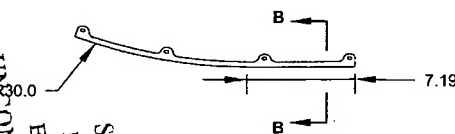
D3508-3 FLAT PATTERN



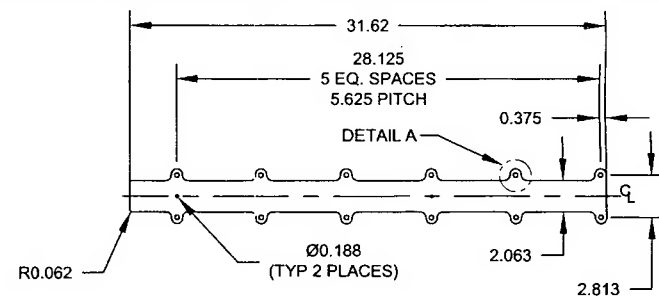
**D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)**



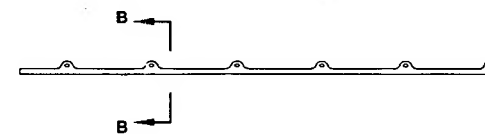
D3508-9F FLAT PATTERN



**D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)**



D3508-5 FLAT PATTERN



**D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)**

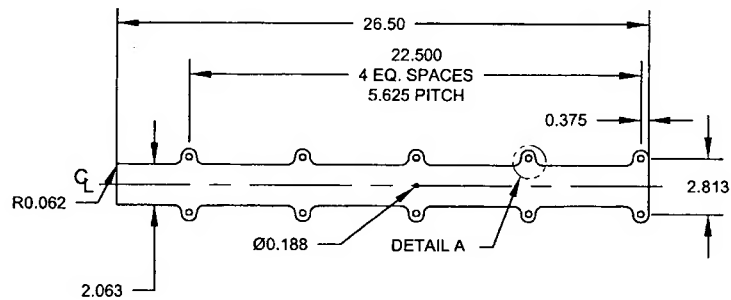
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs, D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs, D3508-13 - 0.25 lbs

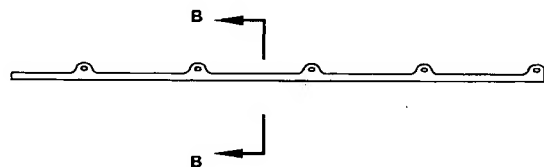
RELEASED
07/11/16

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.04.20		
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3508 TITLE WEARPLATE SCALE 1:8 REV. C SHEET 1 OF 2 COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

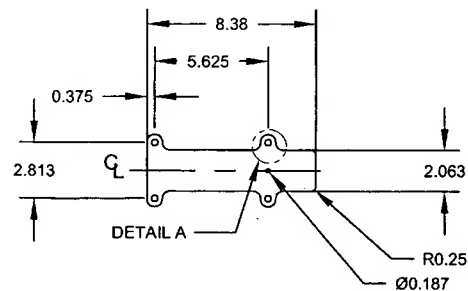
NO. 36479
WORK ORDER
ENGINEERING
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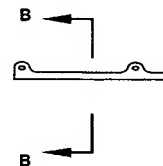
D3508-11F FLAT PATTERN



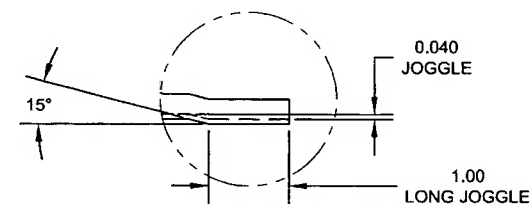
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



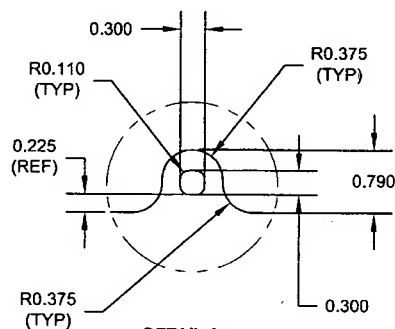
D3508-13F FLAT PATTERN



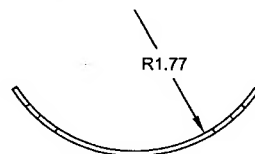
D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



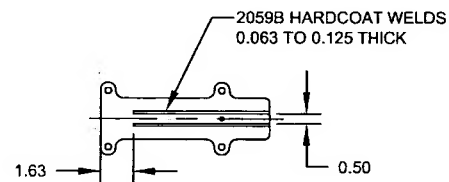
DETAIL C
(SCALE 1:2)



DETAIL A
(SCALE 2:3)



SECTION B-B
(SCALE 2:3)



D3508-13 WELDING DETAIL

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:1
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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